

Date: Tuesday, 3/11/2008 10:28:35 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STEP HI LONG		
Job Number	37778		Part Number	D32721		
Estimate Number	12897		Drawing Number	D3272 REV B		
P.O. Number			Project Number	N/A		
This Issue	3/11/2008	S.O. No.	Drawing Revision	B		
Prsht Rev.	NC		Material			
First Issue	/ /	Type	Due Date	3/25/2008	Qty:	10
Previous Run	37639		Um:	Each		
Written By						
Checked & Approved By						
Comment	Est Rev:A New Issue 07-06-09 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2622-120 Extrusion <u>36923</u>		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

SAD 08/04/10 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
		 <u>08/04/10</u> (10)

Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
		 <u>5A1 08/04/10</u> (10)

Comment: PACKAGING RESOURCE #1

 Identify and Stock:  
 Location: WA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 10:28:35 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP HI LONG

Job Number: 37778

Part Number: D32721

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/14 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-11

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

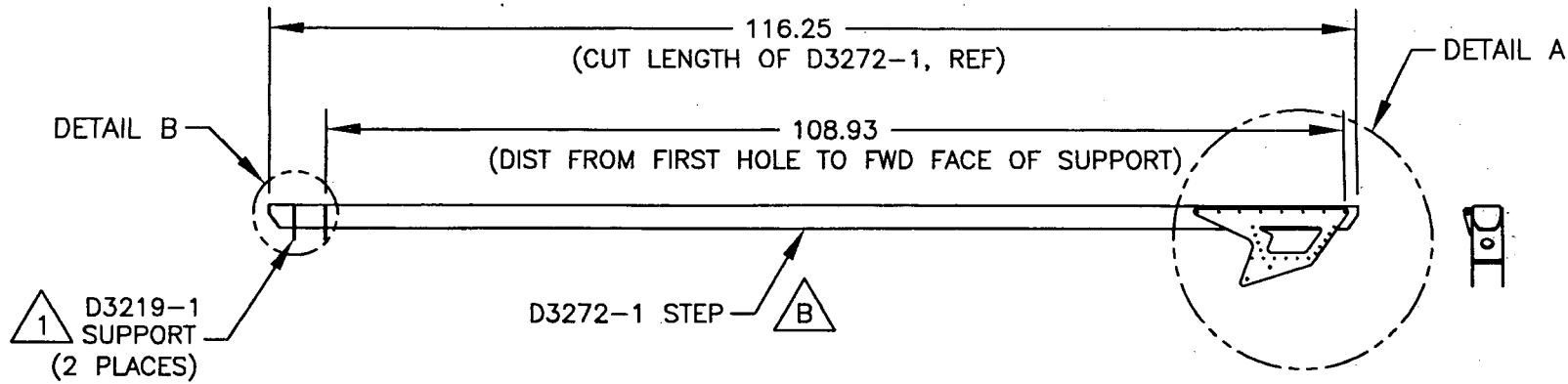
**RELEASED**07 06 04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

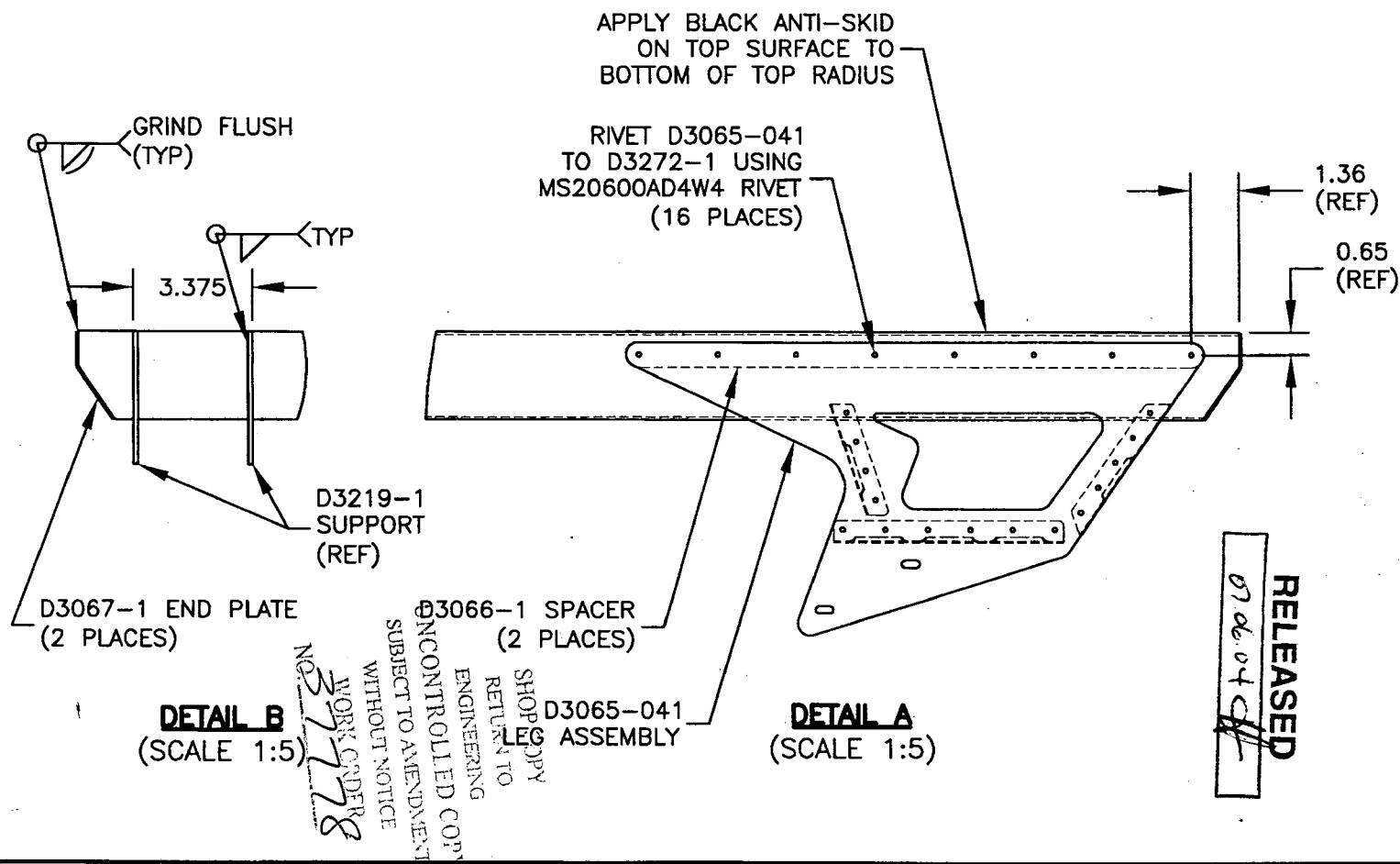
**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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 WITHOUT NOTICE  
 WORK ORDER  
 NO. *37778*



**D3272-041 STEP ASSEMBLY (LH, SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		DRAWING NO. D3272
07.05.18		TITLE STEP ASSEMBLY, LH, LONG
		REV. B SHEET 2 OF 3
		SCALE 1:20

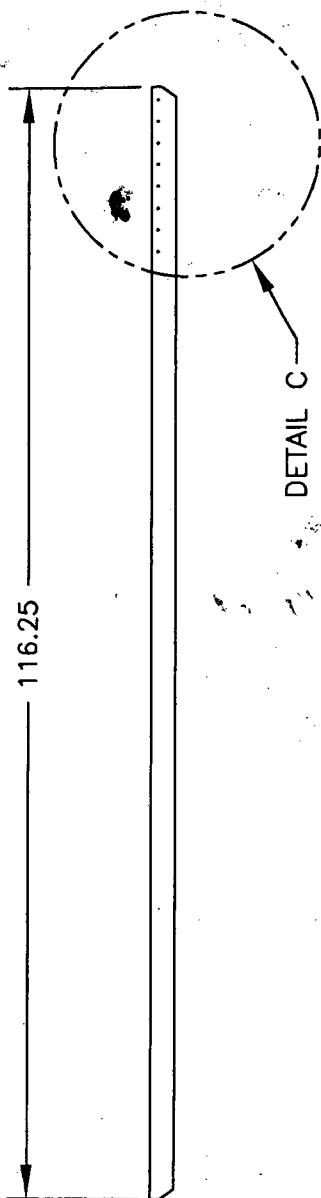
**DART**

**DART**

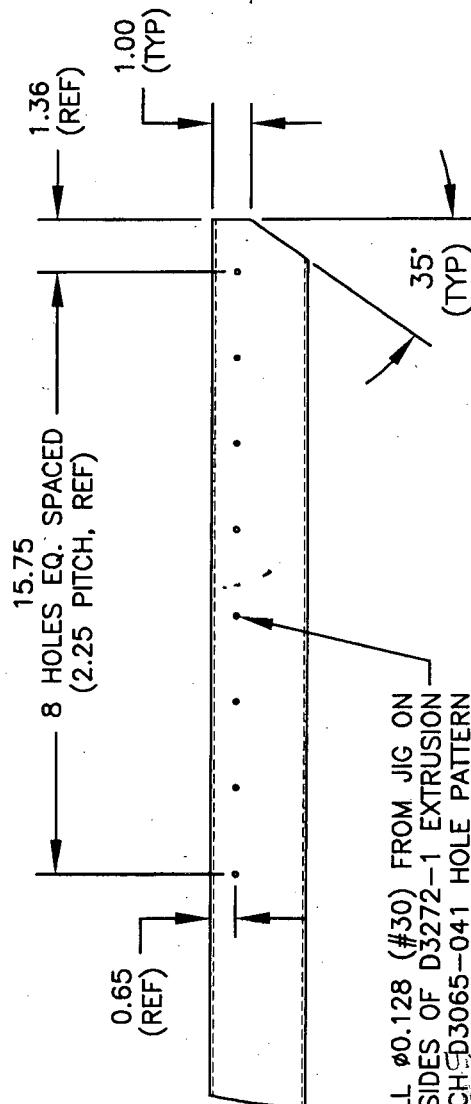
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CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	07.05.18	D3272	SHEET 3 OF 3

SCALE

1:20



**D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



**DETAIL C**  
(SCALE 1:5)

DRILL #0.128 (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

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NO 37778

RELEASED  
07.06.04

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